

Date:
User:Monday, 02/02/2009 3:45:55 PM
Julie Dawson

Process Sheet

AS

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : D119 HELI UTILITY BASKET
Job Number : 45425	
Estimate Number : 12452	
P.O. Number :	Part Number : D119756041 ✓
This Issue : 02/02/2009 S.O. No. :	Drawing Number : IIN PG11-12
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 37596	Material :
Written By :	Due Date : 15/03/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JD 09.02.03</u>	
Comment : Est Rev: A New Issue 06-06-14 JLM Est Rev. B 06.07.26 dwg revB, picklist EC est rev C revC dwg 07.04.09 EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD119-756-041 CHG 002



2.0 45425A BASKET LID ASS'Y (A119)

Comment: Sub-Component BASKET LID ASS'Y (A119) SUB-COMPONENT
1 x D3515-041 Batch: B45425A

3.0 45425B BASKET BASE ASS'Y (A119)

Comment: Sub-Component BASKET BASE ASS'Y (A119) SUB-COMPONENT
1 x D3516-041 Batch: B45425B

4.0 D2022101 Spacer

Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Spacer
Batch: B39880

5.0 D2258220 Placard

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Placard
Batch: 41266

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET

Job Number: 45425

Part Number: D119756041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D2332041	Lid Prop Assembly 6.69" long
-----	----------	------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Lid Prop Assembly 6.69"
Batch: 43721

SS 09/03/10 (X)

7.0	D2530	Handle Weldment
-----	-------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Handle Weldment
Batch: 43799

SS 09/03/10 (X)

8.0	D2535	Spring
-----	-------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Spring
Batch: B39670

SS 09/03/10 (X)

9.0	D2537	Bushing
-----	-------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bushing
Batch: 39153

SS 09/03/10 (X)

10.0	D2931	Bumper
------	-------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bumper
Batch: 21139

SS 09/03/10 (X)

11.0	D35191	Placard
------	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
placard
Batch: 37642

SS 09/03/10 (X)

12.0	AN316A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bolt
Batch: M109798

SS 09/03/10 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 45425

Part Number: D119756041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	AN47A	Bolt
------	-------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: 108928

SS 09/03/10 (X)

14.0	AN422A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: 107715

SS 09/03/10 (X)

15.0	AN424A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M 108255

SS 09/03/10 (X)

16.0	AN517A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M 110303

SS 09/03/10 (X)

17.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M 110503

SS 09/03/10 (X)

18.0	AN960JD416L	Washer
------	-------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M 110153

SS 09/03/10 (X)

19.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M 110303

SS 09/03/10 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 45425

Part Number: D119756041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	AN960JD8	Washer
------	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M110382

21.0	AN9704	Washer
------	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M110704

22.0	MS20600AD4W3	Cherry Rivets
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch: M164715

23.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M110399

24.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M109282

25.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M110382

26.0	D37571	Blanking Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Blanking Plate

batch: B 38775

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 45425

Part Number: D119756041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	AN311A AN310A	Bolt
------	-----------------------------	------



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bolt

batch

~~M169927~~ Returned.

M17566

SS 09/03/10 (X)

28.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Washer

batch

M11039

SS 09/03/10 (X)

29.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Nut

batch

M110399

SS 09/03/10 (X)

30.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D119-756

SS 09-03-12 (X)

31.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

0903-12 (1)

32.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

33.0	D119756011	Clamp
------	------------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CLAMP KIT

Batch:

B29563

SS 09/03/10 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 45425

Part Number: D119756041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0	D26173	Bushing
------	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bushing *B44360*

35.0	D26175	Spacer
------	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Spacer *B45663*

36.0	D351611	Clevis
------	---------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
CLEVIS
batch: *37619*

37.0	D35171	Strut
------	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
STRUT
Batch: *45566 R9/3/18 (2)*

38.0	D3518041	Strut Assembly
------	----------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
FWD ARM ASSEMBLY
Batch: *B38932*
~~*B45567*~~ ~~*B38933*~~ x2

39.0	D35201	Spacer
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
SPACER *B 37623 x1* *B45568 x1*

40.0	AN413A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: *M110865*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: D119 HELI UTILITY BASKET

Job Number: 45425

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN415A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Batch:

M110399

42.0

AN420A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch:

M116895

43.0

AN510A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch:

M110303

44.0

AN960JD416

Washer



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Batch:

M110523

45.0

AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch:

M110153

46.0

AN960JD516L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch:

M114477

47.0

MS21042L4

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Batch:

M109282

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET

Job Number: 45425

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8 09/03/18 (A)

49.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119

Location: _____

PPP Rev: _____

Revc

8 09/03/18 (A)

50.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/19 (A)

Job Completion



MF 09-03-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 REPLACEMENT PARTS

Figures 4 and 5 list components of the Dart *Heli-Utility-Basket™* which can be replaced if required. Their part numbers are included for reference only, and are normally included with the D3515-041 Basket Lid Assembly or the D3516-041 Basket Base Assembly.

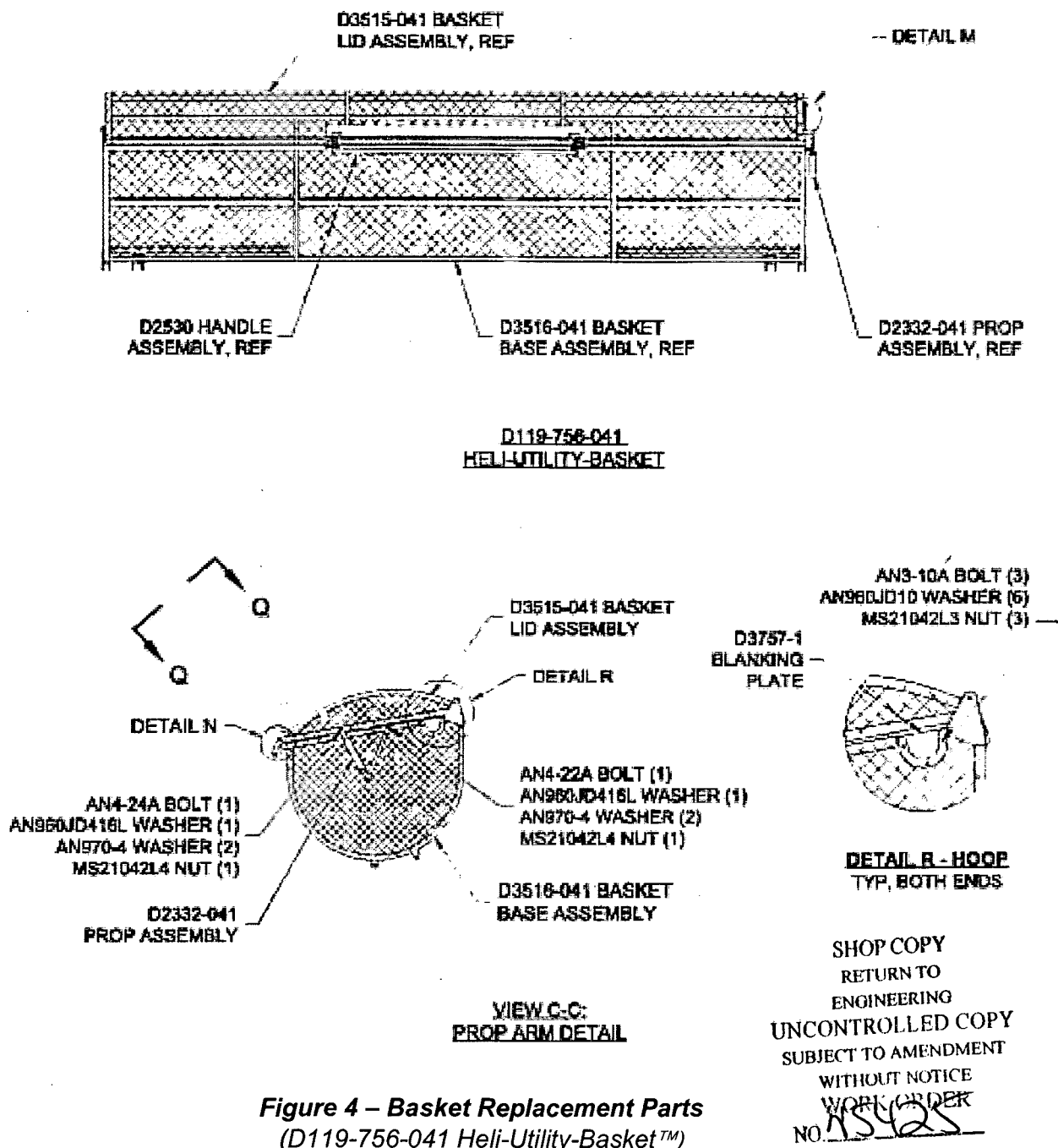
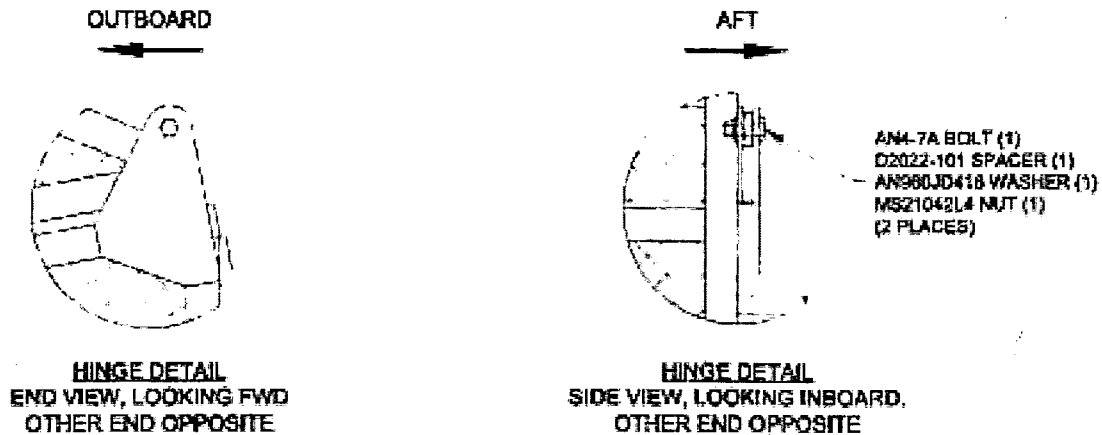


Figure 4 – Basket Replacement Parts
(D119-756-041 Heli-Utility-Basket™)

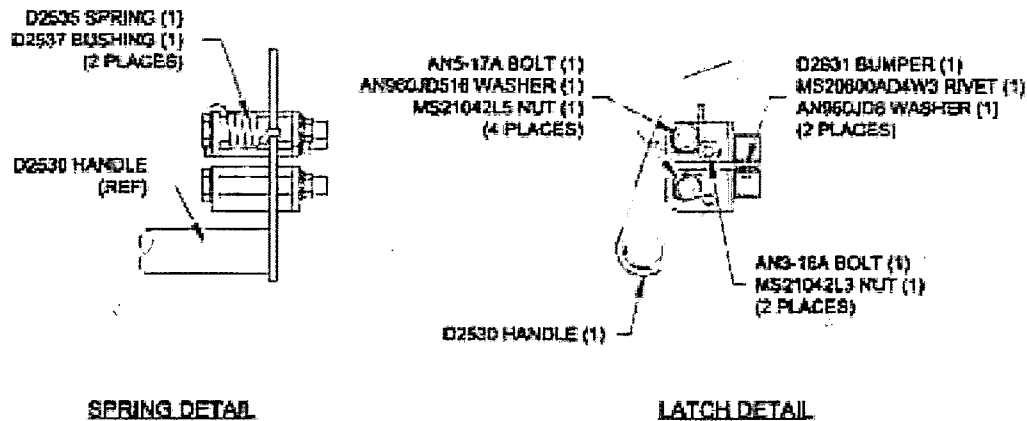
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Revision: **D**

Date: 08.05.07



DETAIL M: HINGE



DETAIL N: HANDLE WELDMENT

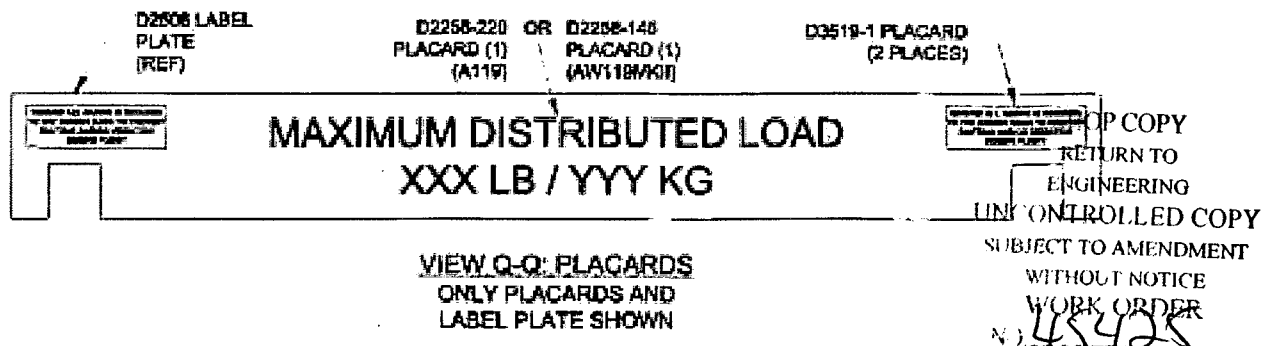


Figure 5 – Basket Replacement Parts & Placards
(D119-756-041 Heli-Utility-Basket™)

5.0 WEIGHT AND BALANCE

There is a negligible weight change associated with the installation of the **D119-756-013 Quick Release Kit**. The following is the weight and balance information for the **D119-756-041 Heli-Utility-Basket™** and the **D119-756-011 Clamp Kit**.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-756-041 Heli-Utility-Basket™ , LH or RH on A119	118.0 lb 53.6 kg	± 46.0 in ± 1.17 m	± 5428.0 lb-in ± 62.7 kg-m	120.0 in 3.05 m	14160 lb-in 163.5 kg-m
D119-756-011 Clamp Kit , LH or RH on A119	0.8 lb 0.36 kg	± 24.5 in ± 0.62 m	± 19.6 lb-in ± 0.22 kg-m	120.0 in 3.05 m	96.0 lb-in 1.1 kg-m
D119-756-041 Heli-Utility-Basket™ , RH only on AW119MKII	118.0 lb 53.6 kg	+ 48.0 in + 1.22 m	+ 5664.0 lb-in + 65.4 kg-m	120.0 in 3.05 m	14160 lb-in 163.5 kg-m
D119-756-011 Clamp Kit , RH only on AW119MKII	0.8 lb 0.36 kg	+ 26.5 in + 0.67 m	+ 21.2 lb-in + 0.24 kg-m	120.0 in 3.05 m	96 lb-in 1.1 kg-m

6.0 POSSIBLE QUICK RELEASE PIN REPLACEMENT

Bolt	Minimum Grip	Replacement Pin P/N
AN4-15A	1.20" (30.5mm)	AVIBANK: BLC4B12S, BLC4TA12S, BLC4R12S, BLC4LA12S MS NUMBER: MS17984C412, MS17985C412, MS17986C412, MS17987C412 REID TOOLS: BLRS-020

NOTE: The qty(2) AN4-15A bolts that secure the D3517-1 Struts mounted on the Basket Base to the D3516-11 Clevises and the qty(2) AN4-15A bolts that secure the top of the Basket Base to the D3518-041 Strut Assemblies may be replaced with stainless steel positive locking quick release pins with a minimum double shear strength of 2400 lbs and 0.25" diameter (10700N and 6.4mm diameter). The **Dart D119-756-013 Quick Release Kit** can be procured from Dart to provide the necessary quick release hardware.

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45425

7.0 PARTS LIST

Qty -041	Qty -011	Qty -013	Part Number	Description
X			D119-756-041	HELI-UTILITY-BASKET™
1	X		D119-756-011	CLAMP KIT
		X	D119-756-013	QUICK RELEASE KIT
2			D2022-101	* SPACER
1			D2258-220	PLACARD (A119)
1			D2258-146	PLACARD (AW119MKII)
1			D2332-041	* PROP ASSEMBLY
1			D2530	* HANDLE ASSEMBLY
2			D2535	* SPRING
2			D2537	* BUSHING
2	2		D2617-3	BUSHING
4	4		D2617-5	BUSHING
	4		D2732-032	RUBBER CUSHION
2			D2931	* BUMPER
	1		D3041-1	CLAMP (A119)
	1		D3041-3	CLAMP (A119)
	1		D3041-5	CLAMP (A119)
	1		D3041-7	CLAMP (A119)
	1		D3789-1	CLAMP (AW119MKII)
	1		D3789-3	CLAMP (AW119MKII)
	1		D3789-5	CLAMP (AW119MKII)
	1		D3789-7	CLAMP (AW119MKII)
1			D3515-041	* BASKET LID ASSEMBLY
1			D3516-041	* BASKET BASE ASSEMBLY
2			D3516-11	CLEVIS
2			D3517-1	STRUT
2			D3518-041	STRUT ASSEMBLY
2			D3519-1	* PLACARD
2			D3520-1	SPACER
2			D3757-1	* BLANKING PLATE

* indicates that part is pre-assembled on basket for customer

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NO. 48425

Qty -041	Qty -011	Qty -013	Part Number	Description
6			AN3-10A	* BOLT
2			AN3-16A	* BOLT
2			AN4-7A	* BOLT
2			AN4-13A	BOLT
6			AN4-15A	BOLT
	2		AN4-17A	BOLT
2	2		AN4-20A	BOLT
1	2		AN4-22A	* BOLT
1	2		AN4-24A	* BOLT
2			AN5-10A	BOLT
4			AN5-17A	* BOLT
2			AN960JD416	* WASHER
40	4		AN960JD416	WASHER
2			AN960JD416L	* WASHER
4			AN960JD416L	WASHER
4			AN960JD516	* WASHER
2			AN960JD516L	WASHER
2			AN960JD8	* WASHER
12			AN960JD10	* WASHER
4			AN970-4	* WASHER
		4	BLRS-020	POSITIVE LOCKING QUICK RELEASE PIN
2			MS20600AD4W3	* RIVET
8			MS21042L3	* NUT (OR MS21042-3)
4			MS21042L4	* NUT (OR MS21042-4)
10	4		MS21042L4	NUT (OR MS21042-4)
4			MS21042L5	* NUT (OR MS21042-5)

* indicates that part is pre-assembled on basket for customer

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